

### **ABSTRACT**

A method for preserving image squareness and image on image registration in a system having a plurality of imaging stations, each imaging station having an ROS. The method includes adjusting the target skew of a reference ROS within one of the plurality of imaging stations by the angular difference between the actual reference ROS position and the target position for the reference ROS and adjusting the target skew of the reference ROS by the skew of the reference ROS relative to the desired skew for image squareness.